

Slip Friday 30

Work Order ID 58053

April 22, 2010 11:56:09 AM



Page 1

Item ID: D4039-043

Accept



Setup Start



Revision ID:

Item Name: Aft Bracket Assembly

Stop



Start Date: 22/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

11

Date: 10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4039	A								

100



Small Fab

Small Fab

Memo

1- Assemble lanyard to bracket as per dwg

0.00

0.00

SB 10/04/29

(C)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 10/04/29

(X)

120



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

10-4-29 SB (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April 22, 2010 11:56:09 AM

Page 2



Item ID: D4039-043

Accept



Setup Start



Revision ID:

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Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/30 *[Signature]*
mf
10-4-29

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Picklist Print

April 22, 2010 11:56:13 AM

Page 1

Work Order ID: 58053

Parent Item: D4039-043

Parent Item Name: Aft Bracket Assembly



Comments: IPP RevA: new issue DD 09.12.15 verified by:EC

Start Date: 22/04/2010

Required Date: 29/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4039-3 		Manufactured	No			100	Each	0.0000	2.0000			
Aft Bracket								57993			SB 10/04/29	(1)
D2690-6 		Manufactured	No			100	Each	7.0000	2.0000			
Lanyard Assembly												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST021

7

50665

7

BLRS-010

Purchased

No

100

Each

42.0000

2.0000

Pip Pin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST283

42

112689

22

113779

20

MS27039-1-11

Purchased

No

100

Each

83.0000

2.0000

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST291

83

9662

83

SB 10/04/29 (1)

SB 10/04/29 (1)

SB 10/04/29 (1)

SB 10/04/29 (1)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April 22, 2010 11:56:13 AM

Page 2

Work Order ID: 58053



Parent Item: D4039-043



Parent Item Name: Aft Bracket Assembly

Start Date: 22/04/2010

Required Date: 29/04/2010

Comments: IPP RevA: new issue DD 09.12.15 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 Nut		Purchased	No			100	Each	1,087.000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1087

113537

103

113644

984

NAS1149D0363J

Purchased

No

100

Each

1,630.000

6.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST298

1630

113288

2

114292

1628

April 22, 2010 11:56:13 AM

Shop Packet Print

Page 2

SS 10/04/29 ①

SS 10/04/29 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

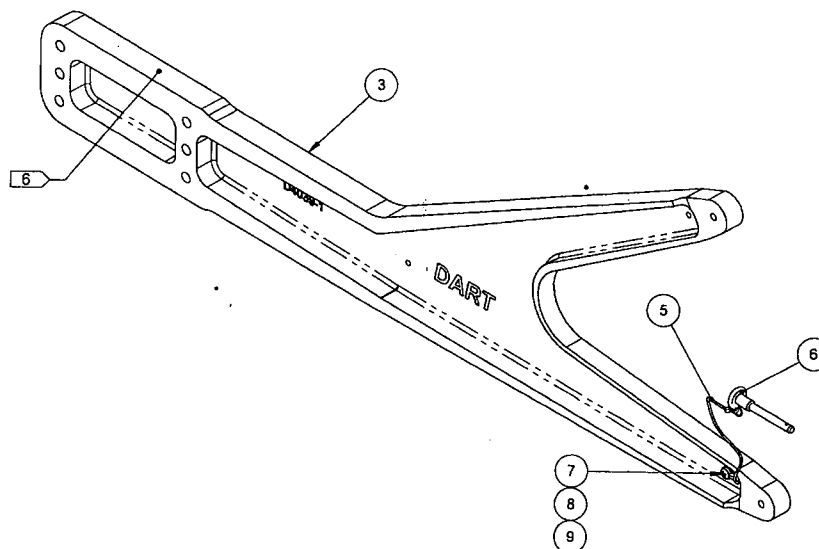
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

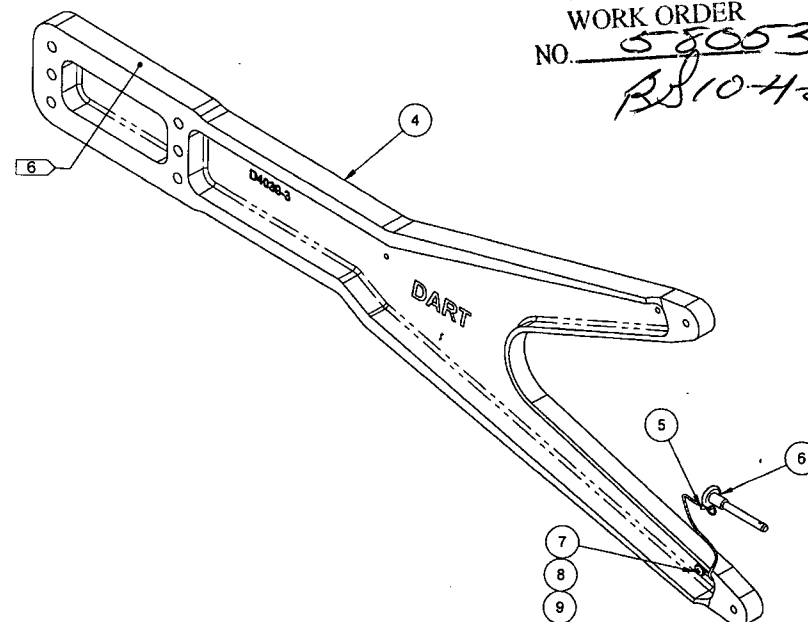
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ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58053
RS10-422

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.12.14			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4039	REV. A
TITLE BRACKET	SCALE NTS
SHEET 1 OF 3	

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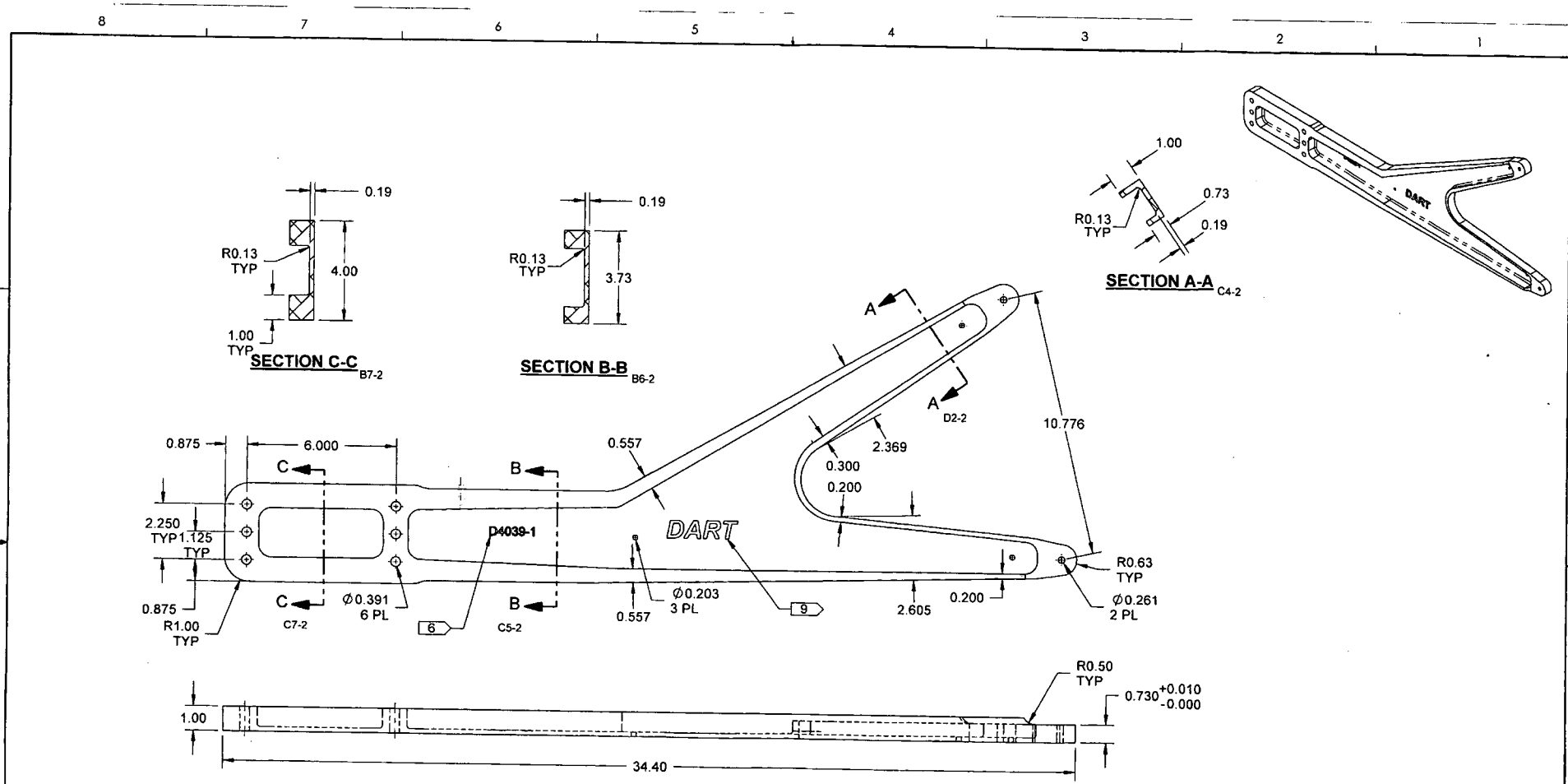
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D4039-1 FWD BRACKET

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
 - 7) WEIGHT: 6.64 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4039-1 REVA.SLDPRT"
 - 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED
2010-04-16

WLO 58053

DESIGN	45	DART AEROSPACE LTD	REV. A
DRAWN	45	HAWKESBURY, ONTARIO, CANADA	
CHECKED	45	DRAWING NO.	SHEET 2 OF 3
MFG. APPR.	45	D4039	SCALE
APPROVED	45	TITLE	NTS
DE APPR.	45	BRACKET	
DATE	09.12.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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